

## ABSTRACT

An automatic lathe is provided which is capable of rapidly and easily switching between machining of a material with a guide bush and machining of the material without the guide bush. The automatic lathe has a head stock (6) and a guide bush support table (1). The head stock (6) is provided with a spindle drive motor (8). The guide bush support table (1) is provided with a guide bush rotating motor (11). There are provided: support table fixing means (15) for positioning and fixing the guide bush support table (1); a guide member (12) rotatably installed on the guide bush support table (1) and regulated so as not to move forward and backward and having a through-hole formed for a spindle (3) to be inserted therein; a guide bush (4) detachably fitted to the tip of the guide member (12); and spindle fixing means (37) for positioning and fixing the spindle (3) on the guide bush support table (1) at a specified position when the guide bush (4) is removed from the guide member (12).